













Date: Tuesday, 30/01/2007 11:03:36 AM
User: Linda Lacelle

Process Sheet

PRELIMINARY ISSUE

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR DOUBLER
Job Number	: 30495		
Estimate Number	: 12680		
P.O. Number	:	Part Number	: D35941
This Issue	: 30/01/2007 S.O. No. :	Drawing Number	: D3594 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: U/R
Previous Run	:	Material	:
Written By	: 	Due Date	: 31/01/2007 Qty: 2 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev :A New Issue 07-01-22 EC		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
			
Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.1155 sf(s) 6061-T6 .080 Sheet Batch: <u>m102448</u> <u>ml 07 01 30</u> (2)			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: <u>U/R</u> Prog Rev: <u>U/R</u> <u>ml 07 01 30</u>			
2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 07 01 30</u> (2)			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK ENGINEERING APPROVAL <u>ml 07 01 30</u> (2)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>ml 07 01 30</u> (2)			

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07-01-30 (1)

8.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07-01-30 (2)

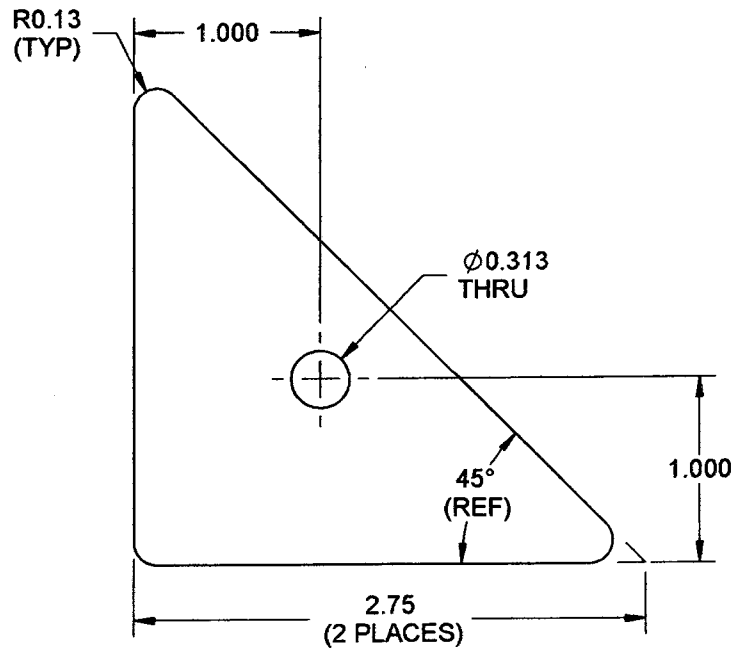
Job Completion



07-01-30

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3594	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE DOOR DOUBLER		SCALE 1:1



D3594-1 DOOR DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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